

Work Order ID 75902

\*75902\*

Page 1

November-01-11 2:24:06 PM

Item ID: D412-742-013

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Float Skidtube Installation

Stop \*NS2\*

Start Date: 01/11/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/10 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9517	B
IIN D412-742	D

100

\*100\*

DOCUMENT CONTROL

0.00

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D412-742-013

CHG006

CHG007  
9/11/08

Sizluly

CHG007  
M.L.J 12-1-3

110

\*110\*

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

12/1/20

B75906

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 75902**

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**\*75902\***

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**Item ID:** D412-742-013**Accept****\*N900040100\*****Setup****Start****\*NS1\*****Revision ID:****Item Name:** Float Skidtube Installation**Stop****\*NS2\*****Start Date:** 01/11/2011 **Start Qty:** 1.00**\*1\*****Cust Item ID:****Required Date:** 15/11/2011 **Req'd Qty:** 1.00**\*1\*****Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:****Run****Start****\*NR1\*****QC:****Date:****SPC (Y/N):****Date:****Stop****\*NR2\*****Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

120

**\*120\***

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

W

12-01-06(1)

130

**\*130\***

Packaging

Packaging

0.00

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-742-013  
Location: 73

ff

12/1/12

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/1/12

MF  
12-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 75902

\*75902\*

Parent Item: D412-742-013

\*D412-742-013\*

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev: A05.10.13 New Issue KJ/JLM  
 IPP Rev:B 06-06-08 As per DS19336 JLM IPP RevC 07-12-03 ECN  
 1072 DD verified by:JLM  
 IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC  
 IPP Rev:E 09-01-23 as per DS19441 DD verified by:EC IPP RevF: add  
 AN4C7A DD 10.01.13 verified by:EC IPP Rev:G 11.11.01 as per  
 DS19517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C53A~  *AN4C53A* Bolt		Purchased	No		110	Each	21.0000	4	4	4	**	M9688	6
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST361		21							
				115723		10							
				119447		11							
AN4C7A~  *AN4C7A* Bolt		Purchased	No		110	Each	315.0000	4	4	4	**	S	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		315							
				109147		315							
D3403-5~  *D3403-5* Bushing		Manufactured	No		110	Each	108.0000	8	8	8	**	12/11/2011	6
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG052		100							
				74761		100							
				ST361		8							
				66530		8							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75902

\*75902\*

Parent-Item: D412-742-013

\*D412-742-013\*

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D412-742-043

Manufactured No

110 Each

0.0000

1

1

\*\*

1

B75902 12/11/11

\*D412-742-043\*

Replacement Float Skidtube

D2571

Manufactured No

110 Each

3.0000

1

1

\*\*

1

B774460 12/11/11

\*D2571\*

Saddle, Fwd Out 205

Location

ST433 3

72969 3

Manufactured No

110 Each

2.0000

1

1

\*\*

1

B773460 12/11/11

\*D2572\*

Saddle, Fwd In 205

Location

ST433 2

71107 2

Manufactured No

110 Each

0.0000

1

1

\*\*

1

B77282 12/11/11

\*D2573\*

Saddle, Aft Out 205

Manufactured No

110 Each

0.0000

1

1

\*\*

1

B77286 12/11/11

\*D2574\*

Saddle, Aft In 205

Manufactured No

110 Each

0.0000

1

1

\*\*

1

B77286 12/11/11

\*D2876\*

Saddle Spacer

Manufactured No

110 Each

23.0000

2

2

\*\*

2

B76949 12/11/11

Location

ST025 23

72136 23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75902

\*75902\*

Parent Item: D412-742-013

\*D412-742-013\*

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2877  
\*D2877\*  
Saddle Spacer

Manufactured	No	110	Each	87.0000	2	2
--------------	----	-----	------	---------	---	---

\*\*

D3403-1  
\*D3403-1\*  
Bushing

Manufactured	No	110	Each	44.0000	8	8
--------------	----	-----	------	---------	---	---

\*\*

D2747  
\*D2747\*  
Set Screw

Manufactured	No	110	Each	126.0000	4	4
--------------	----	-----	------	----------	---	---

\*\*

D3533-1  
\*D3533-1\*  
Set Screw

Manufactured	No	110	Each	84.0000	2	2
--------------	----	-----	------	---------	---	---

\*\*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 75902

\*75902\*

Parent Item: D412-742-013

\*D412-742-013\*

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

AN4C6A  
Bolt  
  
\*AN4C6A\*

Purchased No 110 Each 330.0000 16 16  
\*\*

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	326	
116704	15	
118451	11	
118983	100	
119328	200	

AN4C52A  
BOLT  
  
\*AN4C52A\*

Purchased No 110 Each 61.0000 4 4  
\*\*

Location	Loc Qty	Loc Code
ST361	61	
117163	8	
117688	7	
118451	46	

AN6C12A  
BOLT  
  
\*AN6C12A\*

Purchased No 110 Each 16.0000 8 8  
\*\*

Location	Loc Qty	Loc Code
ST341	16	
118422	16	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 75902

\*75902\*  
\*D412-742-013\*

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Start Qty: 1.00

Required Date: 15/11/2011

Required Qty: 1.00

D3672-3

Manufactured No 110 Each 691.0000 32 32  
\*\*

\*D3672-3\*

Phenolic Washer

Location	Loc Qty	Loc Code
ST074	691	
64176	180	
72230	11	
73487	500	

AN960C416L

Purchased No 110 Each 0.0000 32 32  
\*\*

\*AN960C416I\*

WASHER

D3672-9

Manufactured No 110 Each 232.0000 8 8  
\*\*

\*D3672-9\*

Phenolic Washer

Location	Loc Qty	Loc Code
ST074	232	
35523	232	

NAS1149C0632R

Purchased No 110 Each 88.0000 8 8  
\*\*

\*NAS1149C0632R\*

WASHER

Location	Loc Qty	Loc Code
ST297	88	
118006	88	

D3672-11

Manufactured No 110 Each 99.0000 8 8  
\*\*

\*D3672-11\*

Phenolic Washer

Location	Loc Qty	Loc Code
ST074	99	
58046	99	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 75902

**\*75902\***

Parent Item: D412-742-013

**\*D412-742-013\***

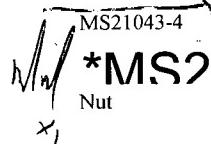
Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

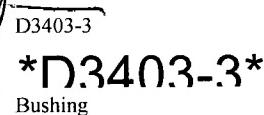
Start Qty: 1.00

Required Qty: 1.00



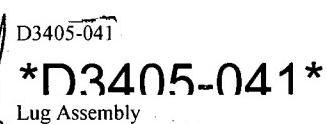
Purchased	No	110	Each	1,105.000	( 29 )	29	**
-----------	----	-----	------	-----------	--------	----	----

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1065	
117793	65	
118686	500	
119309	500	



Manufactured	No	110	Each	13.0000	1 8	29	**
--------------	----	-----	------	---------	-----	----	----

Location	Loc Qty	Loc Code
ST	3	
69509	3	
ST052	10	
71852	10	



Manufactured	No	110	Each	12.0000	1 1	B77000	12.11.08	**
--------------	----	-----	------	---------	-----	--------	----------	----

Location	Loc Qty	Loc Code
ST474	12	
62227	2	
73338	10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 75902

**\*75902\***

Parent Item: D412-742-013

**\*D412-742-013\***

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

D3405-043

Manufactured No

110 Each

6.0000

\*\*

1 B76999

**\*D3405-043\***

Lug Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST423	2	
65703	2	
ST478	4	
73339	4	

AN4C47A

Purchased No

110 Each

57.0000

\*\*

4 4

**\*AN4C47A\***

Bolt

D3407-041

Manufactured No

110 Each

25.0000

\*\*

1 B762235

Tow Ring

D3417-3

Manufactured No

110 Each

60.0000

\*\*

2 12/1/2011

**\*D3417-3\***

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST463	25	
75029	25	
FG	9	
33519	9	
ST053	51	
51648	4	
53182	23	
66847	24	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75902

\*75902\*

Parent Item: D412-742-013

\*D412-742-013\*

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

D3456-1  
Washer

Manufactured No 110 Each 96.0000

✓ 1  
\*\*

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST054	89	
66848	3	
71165	2	
<u>73493</u>	84	

AN3C37A  
BOLT

Purchased No 110 Each 132.0000

✓ 1  
\*\*

111953LS

Location	Loc Qty	Loc Code
ST354	132	
116874	11	
117010	2	
118518	44	
118709	50	
119324	25	

AN3C40A  
BOLT

Purchased No 110 Each 73.0000

✓ 1  
\*\*

12/1/12

Location	Loc Qty	Loc Code
ST354	73	
<u>112454</u>	23	
<u>114442</u>	50	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75902

**\*75902\***

Parent Item: D412-742-013

**\*D412-742-013\***

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

AN3C41A  
\*AN3C41A\*  
BOLT

Purchased No 110 Each 98.0000

1 1

\*\*

Location	Loc Qty	Loc Code
FG	4	
103324	4	

ST354	94	
119035	44	
119324	50	

Purchased No 110 Each 38.0000

1 1

\*\*

Location	Loc Qty	Loc Code
ST354	38	
106176	1	
117763	17	
118131	20	

Purchased No 110 Each 38.0000

1 4

\*\*

Location	Loc Qty	Loc Code
ST354	38	
114455	13	
118387	25	

Purchased No 110 Each 47.0000

5 5

\*\*

Location	Loc Qty	Loc Code
ST355	47	
118758	47	

AN3C43A  
\*AN3C43A\*  
BOLT

AN3C46A  
\*AN3C46A\*  
BOLT

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75902

**\*75902\***

Parent Item: D412-742-013

**\*D412-742-013\***

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

AN960C10L

NAS1149C0332 R

Purchased

No

110

Each

0.0000

1 26 26

\*\*

M119736

X) \*AN960C10I \*

washer

MS21043-3

Nut

Purchased

No

110

Each

727.0000

1 13 13

\*\*

M119901

F 12/1/12

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST301	655	
118077	1	
118614	477	
118686	177	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REF. CANADIAN STC: SH05-37

REF. FAA STC: SR01583SE

REF. EASA STC: EASA.IM.RS.01126

## PURPOSE:

The purpose of this service instruction is to introduce an alternate wearplate installation for the D412-742-011/-013 Skidtube Installations. The new DSI-9517-011 Wearplate Kit consists of new wearplates destined to replace existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets. The components in the DSI-9517-011 Wearplate Kit are as defined in the parts list on sheet 4 of this service instruction.

## INSTALLATION PROCEDURE:

- Replace D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets with D4095-041/-043 Wearplates Assemblies as follows:
1. Remove existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets per Item 32.6.1 of ICA-D412-742. It might be necessary to loosen the aft end of D3564-5 Wearshoe and D3566-5 Gasket.
  2. Remove qty.(4) AN4C52A Bolts, D3403-1 Bushings, and qty.(8) D3672-11 Washers as indicated in Figures 1 and 2 of this service instruction.
  3. Inspect the skidtube and saddles per Chapter 5 of ICA-D412-742.
  4. Seal existing inserts located on both sides of the skidtube in area shown in Figures 1 and 2 of this service instruction using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant.
  5. Locate the DSI-9517-011 Wearplate Kit as shown in Figure 1 and 2 of this service instruction.
  6. Transfer drill qty.(2) Ø0.438 hole from the skidtube/saddle to the D4095-041/-043 Wearplates Assemblies. Deburr. Touch up finish per Item 5.2.14 of ICA-D412-742 as required.
  7. Install the DSI-9517-011 Wearplate Kit using the same AN3C hardware as shown in ICA-D412-742. Torque to 15-25 in-lbs (1.7-2.8 N-m).
  8. Install D3403-5 Bushings and AN4C53A Bolts in lieu of D3403-1 Bushings and AN4C52A Bolts removed at step 2 above. Ensure that the nuts on the AN4C Bolts are on the inboard side of the skidtube. Torque to 50-70 in-lbs (5.7-7.9 N-m).
  9. Amend weight and balance per the Weight and Balance Table below.

## WEIGHT AND BALANCE:

Use the following weight and balance information for DART D412-742-011/-013 skidtube and saddle installations equipped with DSI-9517-011 Wearplate Kit.

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D412-742-011 <i>Float Skidtube Installation with DSI-9517-011 Kit Installed</i>	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg
D412-742-013 <i>Float Skidtube Installation with DSI-9517-011 Kit Installed</i>	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg

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B	ITEM 21B AND 22B REMOVED FROM PARTS LIST	XDF	11.10.11
A	NEW ISSUE	MB	10.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>b</u>	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	XDF		
CHECKED	<u>b</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 1 OF 6
APPROVED	<u>100</u>	TITLE	SCALE
DE APPR.	<u>100</u>	ALTERNATE WEARPLATE KIT	NTS
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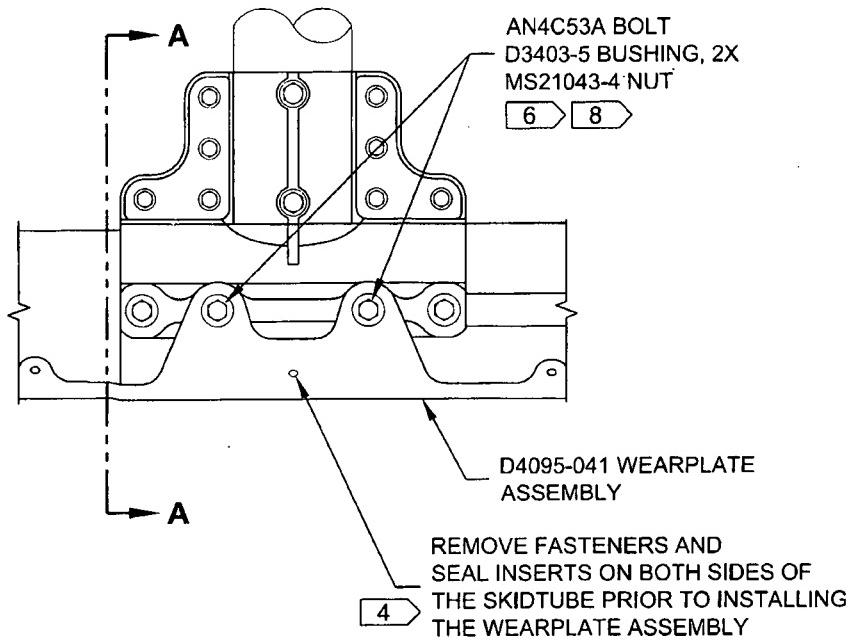
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

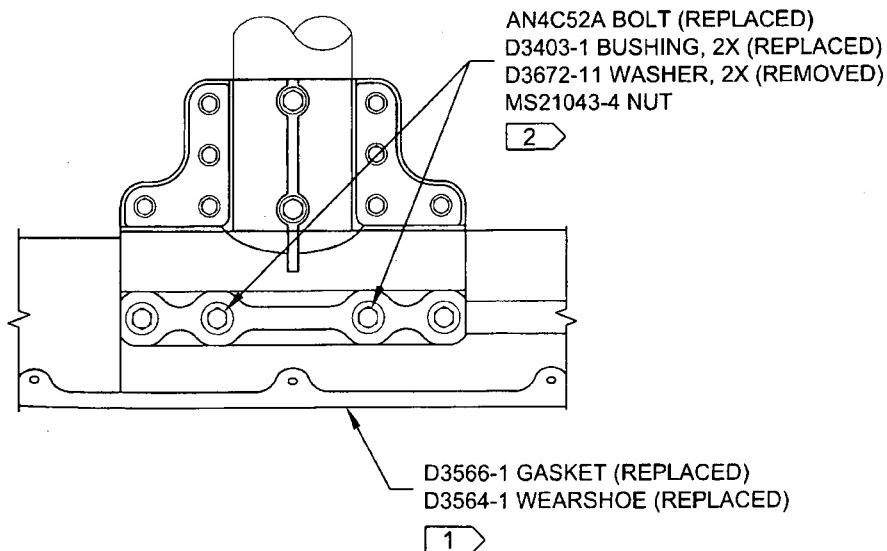
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

IS:



WAS:



**FIGURE 1: CHANGE AT FORWARD SADDLE LOCATION  
WITH DSI-9517-011 KIT INSTALLED**

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APPROVED	<i>10/10</i>	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

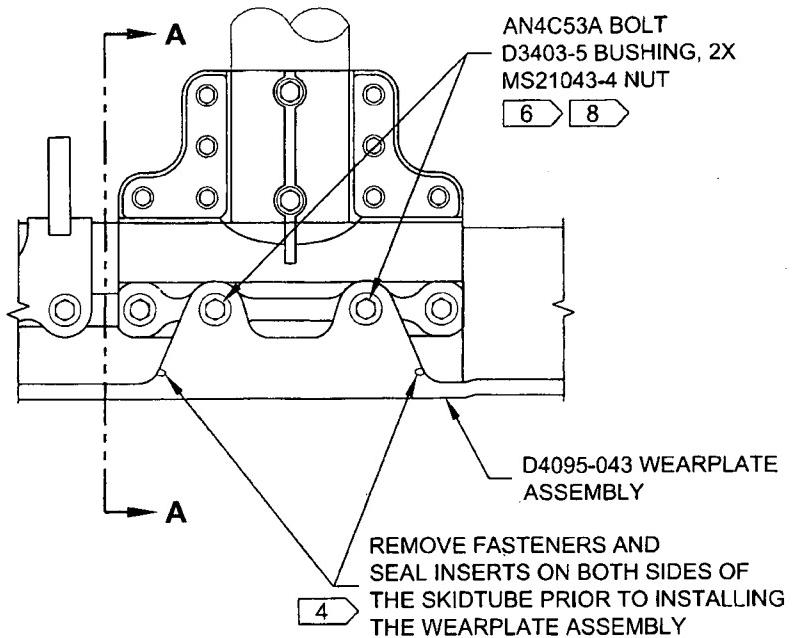
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

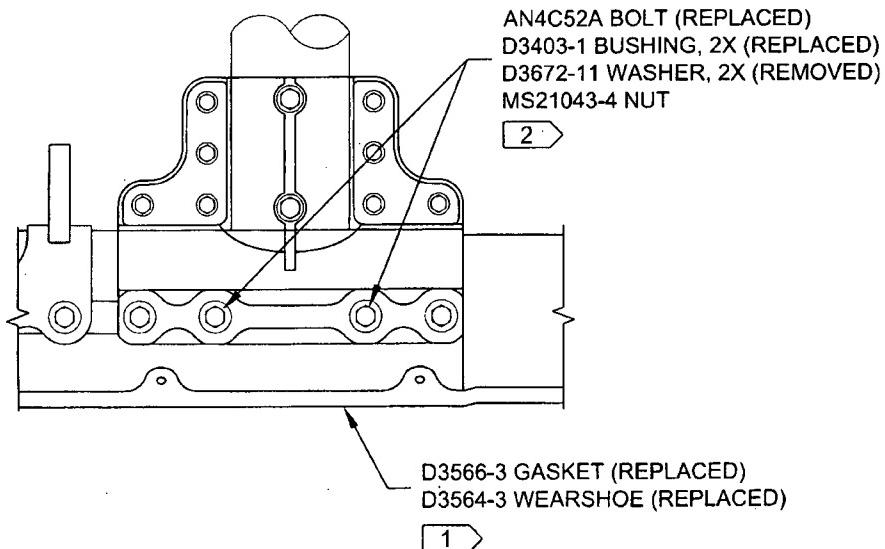
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

IS:



WAS:



**FIGURE 2: CHANGE AT AFT SADDLE LOCATION  
WITH DSI-9517-011 KIT INSTALLED**

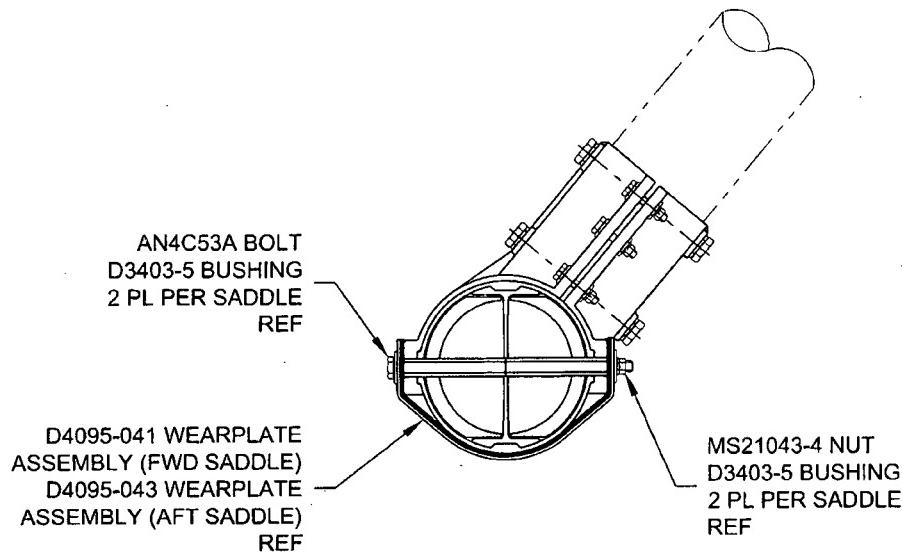
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DRAWN	XDF	KENT, WA	
CHECKED	A	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 3 OF 6
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DE APPR.	11	ALTERNATE WEARPLATE KIT	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



### SECTION A-A

#### DSI-9517-011 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9517-011	WEARPLATE KIT
8	D3403-5	BUSHING
1	D4095-041	WEARPLATE ASSEMBLY
1	D4095-043	WEARPLATE ASSEMBLY
4	AN4C53A	BOLT

DESIGN	<i>b</i>	<b>DART AEROSPACE USA, INC</b> KENT, WA	
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CHECKED	<i>b</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 4 OF 6
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

THE PARTS LISTS IN SECTION 32.15 OF ICA-D412-742 (PAGES 53 AND 55) AND SECTION 5.1 OF IIN-D412-742 (PAGES 16 AND 17) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

**32.15 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)**  
**5.1 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)**

Item	QTY -011	QTY -041	QTY -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1.		X	D412-742-015	ELECTRIC STEP KIT

IS:

3		10		AN3C6A	BOLT (REMOVED QTY.2)
4		4		AN3C7A	BOLT (REMOVED QTY.4)
5		38		AN960C10L	WASHER (REMOVED QTY.6)
21A		1		D4095-041	WEARPLATE ASSEMBLY
22A		1		D4095-043	WEARPLATE ASSEMBLY
46	8			D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8			D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	.4			AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4			AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8			D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12		AN3C6A	BOLT
4		8		AN3C7A	BOLT
5		44		AN960C10L	WASHER
21A		1		D3564-1	WEARPLATE
21B		1		D3564-3	WEARPLATE
22A		1		D3566-1	GASKET
22B		1		D3566-3	GASKET
46	16			D3403-1	BUSHING
49	8			AN4C52A	BOLT
53	16			D3672-11	WASHER

DESIGN	A	DART AEROSPACE USA, INC KENT, WA
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MFG. APPR.	N/A	
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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THE PARTS LISTS IN SECTION 32.16 OF ICA-D412-742 (PAGES 57 AND 59) AND SECTION 5.2 OF IIN-D412-742 (PAGES 18 AND 19) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

**32.16 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)**  
**5.2 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)**

ITEM	QTY -013	QTY -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

**IS:**

3	10	AN3C6A	BOLT (REMOVED QTY.2)
4	4	AN3C7A	BOLT (REMOVED QTY.4)
5	38	AN960C10L	WASHER (REMOVED QTY.6)
21A	1	D4095-041	WEARPLATE ASSEMBLY
22A	1	D4095-043	WEARPLATE ASSEMBLY
46	8	D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8	D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4	AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4	AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8	D3672-11	WASHER (REMOVED QTY.8)

**WAS:**

3	12	AN3C6A	BOLT
4	8	AN3C7A	BOLT
5	44	AN960C10L	WASHER
21A	1	D3564-1	WEARPLATE
21B	1	D3564-3	WEARPLATE
22A	1	D3566-1	GASKET
22B	1	D3566-3	GASKET
46	16	D3403-1	BUSHING
49	8	AN4C52A	BOLT
53	16	D3672-11	WASHER

DESIGN	<i>a</i>	<b>DART AEROSPACE USA, INC</b> KENT, WA	
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CHECKED	<i>b</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 6 OF 6
APPROVED	<i>100</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C.	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**REFERENCE ONLY**

**DART AEROSPACE USA, INC.**

**IIN-D412-742**

Page 18 of 20

**5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List**

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	<b>FLOAT SKIDTUBE INSTALLATION</b>
1	X		D412-742-043	<b>FLOAT SKIDTUBE</b>
		1	D3391-043	<b>412 FLOAT SKIDTUBE</b>
1	*24	*AN3C4A	*BOLT	
3	*12	*AN3C6A	*BOLT	
4	*8	*AN3C7A	*BOLT	
5	*44	*AN960C10L	*WASHER	
21A	*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)	
21B	*1	*D3566-1	*GASKET	
22A	*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)	
22B	*1	*D3566-1	*GASKET	
23A	*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)	
23B	*1	*D3566-5	*GASKET	
10	*1	*D3391-021	<b>*412 FORWARD TUBE</b>	
11	**1	**D3401-041	**TOW CAP	
12A	**10	**AEELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)	
12B	**2	**AEELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)	
13	**10	**AN3C4A	**BOLT	
14A	**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)	
14B	**10	**AN960C10L	**WASHER	
24A	**1	**D3564-13	**WEARSHOE	
24B	**1	**D3566-13	**GASKET	
20	*1	*D3391-023	<b>*412 MID TUBE</b>	
28	**20	**AEELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)	
30	*1	*D3391-025	<b>*412 AFT TUBE</b>	
25A	**1	*D3537-1	**WEARPAD	
25B	**1	*D3553-1	**GASKET	
26A	**1	*D3537-7	**WEARPAD	
26B	**1	*D3553-3	**GASKET	
31	**1	**D2646	**AFT CAP	
32	**14	**AEELS-1032-130	**INSERT	
36	**12	**AEELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)	
37A	**6	**AN3C4A	**BOLT	
37B	**4	**AN3C5A	**BOLT	
38A	**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)	
38B	**10	**AN960C10L	**WASHER	

(CONTINUED ON PAGE 19)

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Revision: D  
 Date: 07.10.04

**REFERENCE ONLY****DART AEROSPACE USA, INC.****IIN-D412-742**

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(CONTINUED FROM PAGE 18)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

\*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

\*\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

THE PARTS LISTS IN SECTION 32.16 OF ICA-D412-742 (PAGES 57 AND 59) AND SECTION 5.2 OF IIN-D412-742 (PAGES 18 AND 19) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

**32.16 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)**  
**5.2 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)**

Item	QTY -013	QTY -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
1	X		D412-742-043	FLOAT SKIDTUBE

IS:

3		10	AN3C6A	BOLT (REMOVED QTY.2)
4		4	AN3C7A	BOLT (REMOVED QTY.4)
5		38	AN960C10L	WASHER (REMOVED QTY.6)
21A	1		D4095-041	WEARPLATE ASSEMBLY
22A	1		D4095-043	WEARPLATE ASSEMBLY
46	8		D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8		D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4		AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4		AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8		D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12	AN3C6A	BOLT
4		8	AN3C7A	BOLT
5		44	AN960C10L	WASHER
21A		1	D3564-1	WEARPLATE
21B		1	D3564-3	WEARPLATE
22A		1	D3566-1	GASKET
22B		1	D3566-3	GASKET
46	16		D3403-1	BUSHING
49	8		AN4C52A	BOLT
53	16		D3672-11	WASHER

DESIGN	<u>4</u>	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	XDF		
CHECKED	<u>4</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 6 OF 6
APPROVED	<u>100</u>	TITLE	SCALE
DE APPR.	<u>MM</u>	ALTERNATE WEARPLATE KIT	NTS
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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37

REF. EASA STC: EASA.I.M.R.S.01126

## INSTRUCTIONS:

- 1) FOR D412-742-011/013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

**5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List**  
**32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List**

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4		AN4C47A	BOLT
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WAS:

63	4		AN4C46A	BOLT
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**5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List**  
**32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List**

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4		AN4C47A	BOLT
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WAS:

63	4		AN4C46A	BOLT
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A	NEW ISSUE		AJS	08.12.19
REV.	DESCRIPTION			BY DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b>		
DRAWN	AJS	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	BOLT CHANGE	NTS	
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